

Work Order ID 149140

Tuesday, July 19, 2016 2:41:47 PM

149140

Page 1

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 7/13/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 20 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								
100		0.00							
100									
HandThermo	Memo	0.14							
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
110									
Small Fab	Memo	0.21							
Small Fab	Assemble as per Dwg D4634-141								
1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe									
2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.									
Batch # <u>M135436</u>									
Expiry Date <u>03/11/2017</u>									
3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer									

①

PC

AUG 11 2016

SMB
16/8/13

DQA:

Date: 09/22/2016



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

AUG 26 2016

Work Order update only ☐

Work Order: 149146		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D4634-141		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5994		Scrap ☐		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-08-22		Step #: 110		QTY Effective: ①			MRB (QSI042) Approval AUG 22 2016		
Description Work Order Deviation				Disposition				Completed By	
WHILE INSTALLING MS20426 AD 3-6 RIVETS THE RIVET WOULD NOT INSTALL WITH OUT DAMAGING LEXAN MATERIAL CAR 153 CAR 16153				DEBRIEVE REPAIR FROM 6061 T6 .020" MATERIAL (2) AND DIMPLE TOP SIDE 1.10 x 0.75" ① INSTALL WITH CB200 ADHESIVE ② INSTALL WITH CCR 26455-3-03 RIVETS (2) LOCATIONS (M135127) See attach. Email				DAS 27 9-89 1603-25	
								Lead hand / Supervisor Approval Verification	
								DAS 9 9-89 16-08-22	
								QC / QA Coordinator Approval	
								DAS 9 9-89 16-08-22	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☒	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	✓ Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 149140***149140***

Page 2

Tuesday, July 19, 2016 2:41:47 PM

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 7/13/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing <i>W/A DAS 9-89</i> Memo	0.00 0.00							DAS 9 9-89
125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						<i>① 1605-22</i>	DAS 6 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>PPP149075</i> Memo	0.00 0.00							DAS 27 9-89 AUG 22 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

149140

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 7/13/2016 **Start Qty:** 1.00 ***1***

Required Date: 7/19/2016 **Req'd Qty:** 1.00 ***1***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

140

QC

0.02

Quality Control

DAS
21
9-89

AUG 23 2016

dm 16/08/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 1

Work Order ID: 149140

149140

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Document release DL VERIFIED BY:JLM
 Dwg Update DL verf: DD
 DL
 DL
 DL
 DL
 IPP Rev B
 IPP Rev C 13/07/09
 IPP Rev D Dwg Update 13/12/23
 IPP REV E Dwg update 14/01/09
 IPP Rev F Dwg. update 14/02/03
 IPP Rev G Dwg. Update 15/01/27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5021-1

Manufactured

No

100

Each

6.0000

1

1

D5021-1

★★

PC

Foam, Center Panel, Fwd

Location

Loc Qty

Loc Code

MF010

6

123921

6

MS20426AD3-4

Purchased

No

100

Each

4,571.000

4

4

MS20426AD3-4

★★

PC

RIVET

(A034 ABS)

Location

Loc Qty

Loc Code

ST312

4571

m134294

4571

MS20426AD4-6

Purchased

No

100

Each

1,987.000

2

2

MS20426AD4-6

★★

PC

Rivet

Location

Loc Qty

Loc Code

GA

276

M128812

16

M133234

260

ST311

1711

M134502

1711

2

AUG 11/2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Page 2

Tuesday, July 19, 2016 2:41:46 PM

Work Order ID: 149140

149140

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased

No

100

Each

193.0000

2

2

MS21059L08

Nut

**

PC

Location

Loc Qty

Loc Code

ST300

193

m134634

93

m134943

100

2

D4634-1

Manufactured

No

100

Each

0.0000

1

1

D4634-1

Fwd, Center Ceiling Panel

**

B149089 snl

D4636-5

Manufactured

No

100

Each

29.0000

1

1

D4636-5

Bracket

**

B149100 shp

Location

Loc Qty

Loc Code

ST115

29

129249

29

D4647-5

Manufactured

No

100

Each

13.0000

1

1

D4647-5

Doubler

**

PC

Location

Loc Qty

Loc Code

MF004

13

125019

5

129252

8

D4664-5

Manufactured

No

100

Each

27.0000

6

6

D4664-5

Spacer

**

PC

Location

Loc Qty

Loc Code

MF004

27

129261

27

6

AUG 11 2016

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Tuesday, July 19, 2016 2:41:46 PM

Work Order ID: 149140

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Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4712-1 Manufactured No

100 Each 0.0000 1

D4712-1

**

Bracket

① 149103 PC
B ~~125000~~

D4732-15 Manufactured No

100 Each 1.0000 1

D4732-15

**

Label

① X B 145086 PC

Location

Loc Qty

Loc Code

MF005

1

123207

1

D4732-19 Manufactured No

100 Each 13.0000 1

D4732-19

**

Label

PC

Location

Loc Qty

Loc Code

MF005

13

120070

1

123209

12

MPNY-750S-9-C Purchased No

100 Each 851.0000 7

MPNY-750S-9-C

**

Mounting Pad

PC

Location

Loc Qty

Loc Code

ST583

851

M130423

851

7

AUG 2 1 2016

AUG 1 1 2016

AUG 2 1 2016

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Shop Packet Print

Page 3

DQA: _____ Date: _____



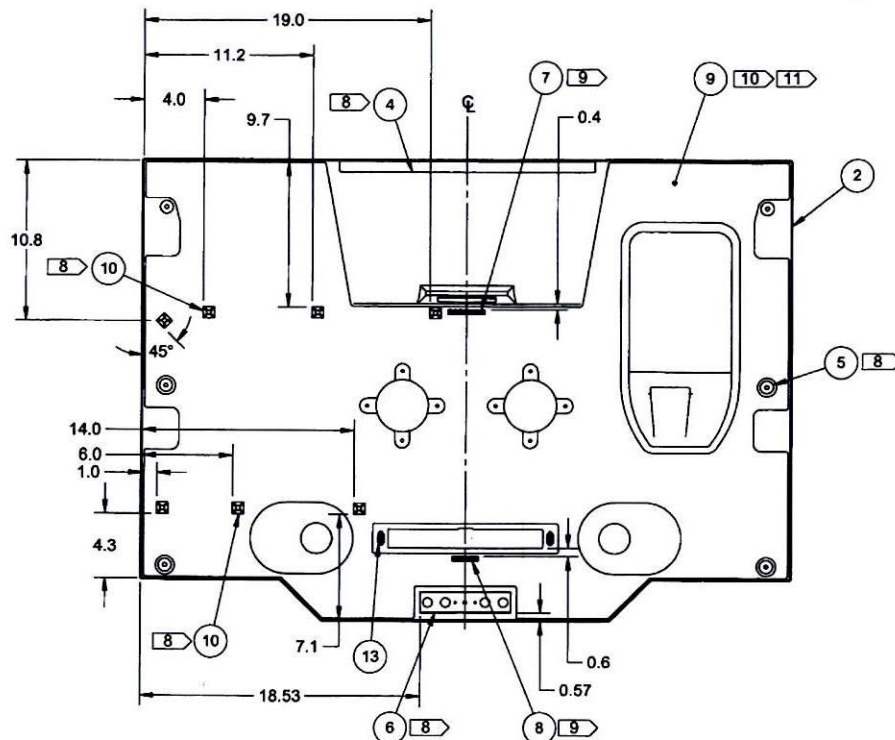
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

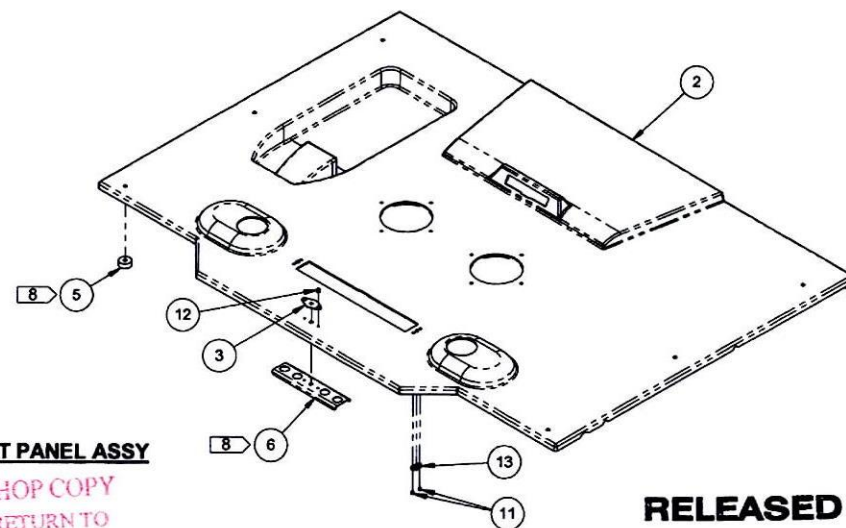


D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

ITEM	QTY	P/N	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	2	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



RELEASED

2015 JAN 26

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149140 MJS
16-07-20

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 7 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Patrick Smith

From: Roberto Fuentes
Sent: Friday, August 19, 2016 10:04 AM
To: Patrick Smith
Cc: William Monterroza; David Bain; David Shepherd; Harvey Siemens
Subject: RE: D4634-141/-143/-145

Hi Pat,

It is acceptable the modification your suggested adding doublers and CCR264SS-3-03 as an alternate to the MS20426AD3-6 rivet for the product is on production to fix the issue.

Roberto

From: Patrick Smith
Sent: August-18-16 12:35 PM
To: Roberto Fuentes <rfuentes@dartaero.com>
Cc: William Monterroza <wmonterroza@dartaero.com>; David Bain <dbain@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>
Subject: RE: D4634-141/-143/-145

Roberto,

At the same time David B. (quitter) was asked, so was I.

I saw the problems he was having and suggested to replace the rivets as a production tweek. I assessed the situation and suggested using an Anchor Nut Rivet (CCR264SS-3-03) when replacing the unacceptable rivet he showed me.

The installer took the initiative not to install the solid rivet in the remainder of the panels and complete the parts with CCR264SS-3-03 which turned out acceptable. (Picture 135324)

On the part which was brought to my concern there was superficial damage when he removed the rivet.

I assessed the situation and rather than scrap the panel I suggest we re-work the part to salvage it.

The fix would be to manufacture two small doublers (Picture:133104 and 133053) from 6061T6 0.020 Aluminum and dimple the top side, alodine, then sandwich the Lexan between the two doubles and bond in place, while attaching the Anchor Nut with CCR264SS-3-03.

I tried the light in place and it had no effect on the fit (picture: 133404 and 133410).

This can all be documented on the work orders as a NCR and a CAR would be generated to update the BOM to call out the CCR264SS-3-03 as an alternate to the MS20426AD3-6 rivet currently called out.

Let me know what you think,

Pat

From: Roberto Fuentes
Sent: Thursday, August 18, 2016 12:11 PM
To: David Bain <dbain@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>
Cc: William Monterroza <wmonterroza@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: RE: D4634-141/-143/-145

Hi David B.

I have review you request with Harvey, and we have questions of our own before to be agree.

- Is it for ease installation. Are we having issues with current ones?
- Have we tried on MS20426AA rivet?
- Would we rather go with "click bond"
- Have tried the "pop" rivets – do they crack the material at edge of the hole?
- What is the cost increase per panel using the "pop" rivet.

Roberto

From: David Bain
Sent: August-17-16 11:28 AM
To: David Shepherd <dshepherd@dartaero.com>; Roberto Fuentes <rfuentes@dartaero.com>
Cc: William Monterroza <wmonterroza@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: D4634-141/-143/-145

David, Roberto,

They are assembling D4634-14X Ceiling Panels on the floor. To mount the Light, we have two nutplates riveted to the ceiling panel using MS20426AD3-4 solid rivets (eg. Sheet 7, Item 10). They are installing these nutplates using a hand bucking tool and have asked if this could be changed to a countersunk POP rivet to simplify the assembly?

Chris suggests we pass this by you for approval before we agree to change anything.

Regards,

David

Patrick Smith

From: Roberto Fuentes
Sent: Friday, August 19, 2016 10:04 AM
To: Patrick Smith
Cc: William Monterroza; David Bain; David Shepherd; Harvey Siemens
Subject: RE: D4634-141/-143/-145

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Subject: D4634-141/-143/-145

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David